

19

1st

DART AEROSPACE LTD	Work Order:	20695
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	10 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HJ	04.04.13	10																																																
2	DC	Photocopy bluefile: K10008 - D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	UK 17 HJ	04.04.23	10																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M14864 / M14416	R11 / CE	15/04/04 / 15.04.04	4 / 510																																																
4	MV	Inspect material for defects or damage prior to machining	ED	04/04/15	10																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	ED	04/04/20	10																																																
6	QC2	Inspect parts as they come off the CNC machine	ED	04/04/20	10																																																
7	MV	Deburr	ED	04/04/20	10																																																
8	QC8 & 5	Second inspection	EE	04.04.20	10																																																
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B19518 / B19599 / B1922 / B20204 / B20655</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B20695</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B20387 / B20089A</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B19486</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M14115 / M1343 / 12207 /</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M14311</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M14312</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14149</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434	12	D2274	Radius Block	B19518 / B19599 / B1922 / B20204 / B20655	2	D2432F	24" Bearpaw	B20695	6	D2438	Clamp	B20387 / B20089A	12	D2529	Washer	B19486	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	M14115 / M1343 / 12207 /	12	AN4-17A	Bolt	M14311	24	AN960JD416	Washer	M14312	12	MS21042L4	Nut (or -4)	M14149	1	Paperwork package from Step 2			CL	04/04/23	10
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SB	04/04/23	10																																																
11	PK	Identify and pack for shipping as per PPP K10008 Rev. E	WCB	04/04/23	10																																																
12	AC	Cost / part 23.77	S4C	04.04.26	10																																																
13	DC	Close W/O 230.72 Inspect Level 21	HJ	04.04.29	10																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

BB 04-04-27

RELEASED
04.02.20

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20695
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	/	NO	Vern	
B	5.500	+/-0.030	5.497	/		"	
C	0.200	+/-0.030	0.201	/		"	
D	0.25 x 45°	+/-0.030	0.249 x 45°	/		"	
E	R0.250	+/-0.030	R0.250	/	NO	Radius gauge	
F	0.250	+/-0.010	0.250	/		MIC	
G	0.625	+/-0.030	0.625	/		Vern	
H	0.375	+/-0.010	0.377	/		"	
I	0.950	+0.030/0.010	0.955	/		"	
J	19.000	+/-0.030	19.060	/		TAPE MEASURE	
K	3.14	+/-0.030	3.14	/		Vern	
L	3.28	+/-0.030	3.28	/		"	
M	Ø0.260	+0.005/-0.000	Ø0.260	/		"	
N	Ø0.93	+/-0.030	Ø0.93	/		"	
O	0.30	+0.030/-0.000	0.309	/		"	
P	23.750	+/-0.030	23.750	/		TAPE MEASURE	
Q	7.375	+/-0.030	7.380	/		Vern	
R	4.250	+/-0.010	4.254	/		"	
S	2.000	+/-0.030	2.015	/		"	
T	9.000	+/-0.010	9.000	/		"	
U	9.000	+/-0.010	9.000	/		"	
V	0.375	+/-0.010	0.380	/		"	

Measured by: ED	Audited by: EC	Prototype Approval:	N/A
Date: 04/01/15	Date: 04.01.15	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	#

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2004
03:42 pm

Work Order No : 0020695

Project Name : *K10008

Project For : WK419

Work Order Type : Main

Main WO Number :

House Part Number : *K10008

Description : Bearpaw kit 19" x 24"

Manufactured : Yes

Amount Req'd : 10

Amount Done : 0

Start Date : 04-12-04

Est Finish Date : 05-05-04

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000%

Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00